

Work Order ID 68431

Wednesday, April 13, 2011 11:00:14 AM

Page 1

Item ID: D3562-041

Accept

Revision ID:

Item Name: Step Assembly, LH

Start Date: 4/13/2011 Start Qty: 3.00

Required Date: 4/29/2011 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3562

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562
2-Deburr and bevel ends for welding

11.04.14 3 0

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

11.04.14

PTO

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

11.04.15

3 0

W/O: 68431

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
14.04.14	110	Change To QC 6	<i>[Signature]</i>	11.04.14			W M 11.04.14

Part No: D3562-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D3562-041

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Setup Start



Revision ID:

Stop



Item Name: Step Assembly, LH

Start Date: 4/13/2011 Start Qty: 3.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(3)			
140 Small Fab Small Fab	Small Fab Memo 1- Transfer drill Rivet holes as per dwg D3562. 2-Touch-up rivet holes with alodine as per dwg d3562 3-Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: 2114158	0.00 0.00				3			
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				43			

SAD
11-04-16

11-04-18

Sulou/18

43
atf

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W/O: 68431		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/05	# 170	change step 6 QCL0 instruction	MA	11.04.05			J. W. 11/04/05

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Wednesday, April 13, 2011 11:00:14 AM



00000000000000000000000000000000

Stop

Abstract

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Cust Item ID:

...the ...

Customer:

Reference:

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. Finally, the fifth step is to evaluate the results of the project. This involves assessing the effectiveness of the plan and identifying any areas for improvement or further action.

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

**Insp.
Stamp**

0.00



HandFinish

Memo

0.00

Hand Finishing

0.00



Powdercoat

M 116 964.

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
RE: ~~2:00~~
2:30

Wing Walk as per dwg QSI005 4.4 Batch 7/11 75 10.00



HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3562-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, LH

Start Date: 4/13/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

EP 5/11/04/29 (3)

230 Pick Kit 0.00



Packaging Memo 0.00

Packaging

GA
w/o 68432 (3x)

EP 5/11/04/29

240 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

MF
11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries




Wednesday, April 13, 2011 11:00:11 AM

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[illegible]**Required Date:** 4/29/2011

Required Qty: 3.00

Comments:	IPP Rev:A	New Issue	06-11-09	JLM
	IPP rev B	ECN 987	07.10.09	EC verified by: DD
	IPP Rev:C	ECN1048	07-12-18	DD verified by:ec
	IPP Rev:D	08-07-28	add chemical conversion coat DD verified by:EC	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C 		Manufactured	No			100	Each	149.0000	1	3		11.04.16	
Step Extrusion													
				<u>Location</u>									
				HALL				20					
				64409				20					
				WA				129					
				46910				2					
				64409				1					
				66970				126		3			
D2734 		Manufactured	No			140	Each	73.0000	2	6		11.04.22	
Step End Plate													
				<u>Location</u>									
				WA015				73					
				66143				73		6			
D3560-041 		Manufactured	No			140	Each	4.0000	1	3		11.04.16	
Arm Weldment													
				<u>Location</u>									
				WA013				4					
				48385				4		3			

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, April 13, 2011 11:00:11 AM

Page 2

Work Order ID: 68431

Parent Item: D3562-041

Parent Item Name: Step Assembly, LH

Start Date: 4/13/2011

Required Date: 4/29/2011

Start Qty: 3.00

Required Qty: 3.00

D3560-043

Manufactured No

140

Each

3.0000

1

3



Arm Weldment



11.04.16

Location

Loc Qty

Loc Code

WA013

3

48387

3

3

MS20600-AD4W5

Purchased

No

160

Each

535.0000

32

96



Blind Rivet



11.04.16

Location

Loc Qty

Loc Code

ST321

379

114382

279

116289

100

WA018

156

111477

156

96

Wednesday, April 13, 2011 11:00:11 AM

Shop Packet Print

Page 2

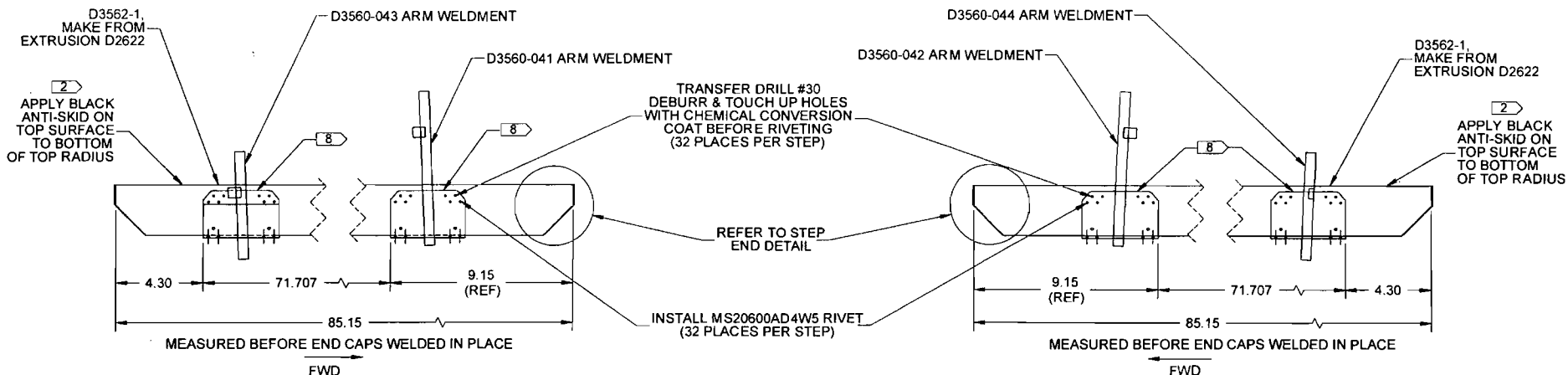
W/O:		WORK ORDER CHANGES					
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D3562-041 LH STEP ASSEMBLY

**TYPICAL STEP END DETAIL
SCALE 1:2**

D3562-042 RH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION

PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR

GREY SANDTEX (4.3.5.6) OR

BLACK SANDTEX (4.3.5.7) OR

GREEN SANDTEX (4.3.5.8) PER DART QSL005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN

THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH

MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

REV.	DESCRIPTION	BY	DATE
E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CR	06.09.26
DESIGN	90		
DRAWN	64		
CHECKED	1E		
MFG. APPR.	1E		
APPROVED	1E		
DE APPR.	1E		
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3562

TITLE

STEP ASSEMBLY

REV. E

SHEET 1 OF 1

SCALE

1:5

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